

Work Order ID 56328

February 17, 2010 2:40:17 PM



Page 1

Item ID:	D3210-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	2/17/10	Start Qty: 12.00		Cust Item ID:		
Required Date:	2/24/10	Req'd Qty: 12.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-2-17	Tooling:	Date:		Run	Start	
	QC:		Date:		SPC (Y/N):	Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3210	Rev A

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3210		<input checked="" type="checkbox"/> Dwg Rev: A	<input type="checkbox"/> Prog Rev: A	<input type="checkbox"/> 2-				
	Deburr if necessary								

RB 10-2-23

16

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

RB 10-2-23

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

8/6/24

115

Pt2 →

W/O: 56328		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/2/24	3 126	Took Qty +1 Part For QC inspection template	S	10/2/24	11		S 10/2/24

Part No: D3210-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56328

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Item ID: D3210-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 2/17/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
	<i>u/n</i>								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
	<i>u/n</i>								
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

= 7 m-h 10/02/25

15X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D3210-1

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Revision ID:

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Item Name: Doubler

Start Date: 2/17/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

0.00

Memo

START TIME:

12:45pm

OVEN TEMPERATURE:

1:15pm FINISH TIME:

370°F

0.00

=) JW 10/02/25 (X15) 9

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8/10/02/25

(X15)

180



Packaging

Packaging

Identify as per dwg & Stock Location: 210

0.00

Memo

0.00

10/03/01 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 2/17/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

C203/0110

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 56328



Parent Item: D3210-1

Parent Item Name: Doubler

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A New Issue 05-11-17 JLM
IPP Rev:B Now On Waterjet 06-10-24 JLM

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	153.0250	31.4905	30,		



2024-T3 .080 sheet



PR 10-2-03

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

153.02505

104921

3

105411

17

107460

4.36

110908

29.52205

112331

24.643

113796

65

15628

6

17695

1.5

18481

2

113796

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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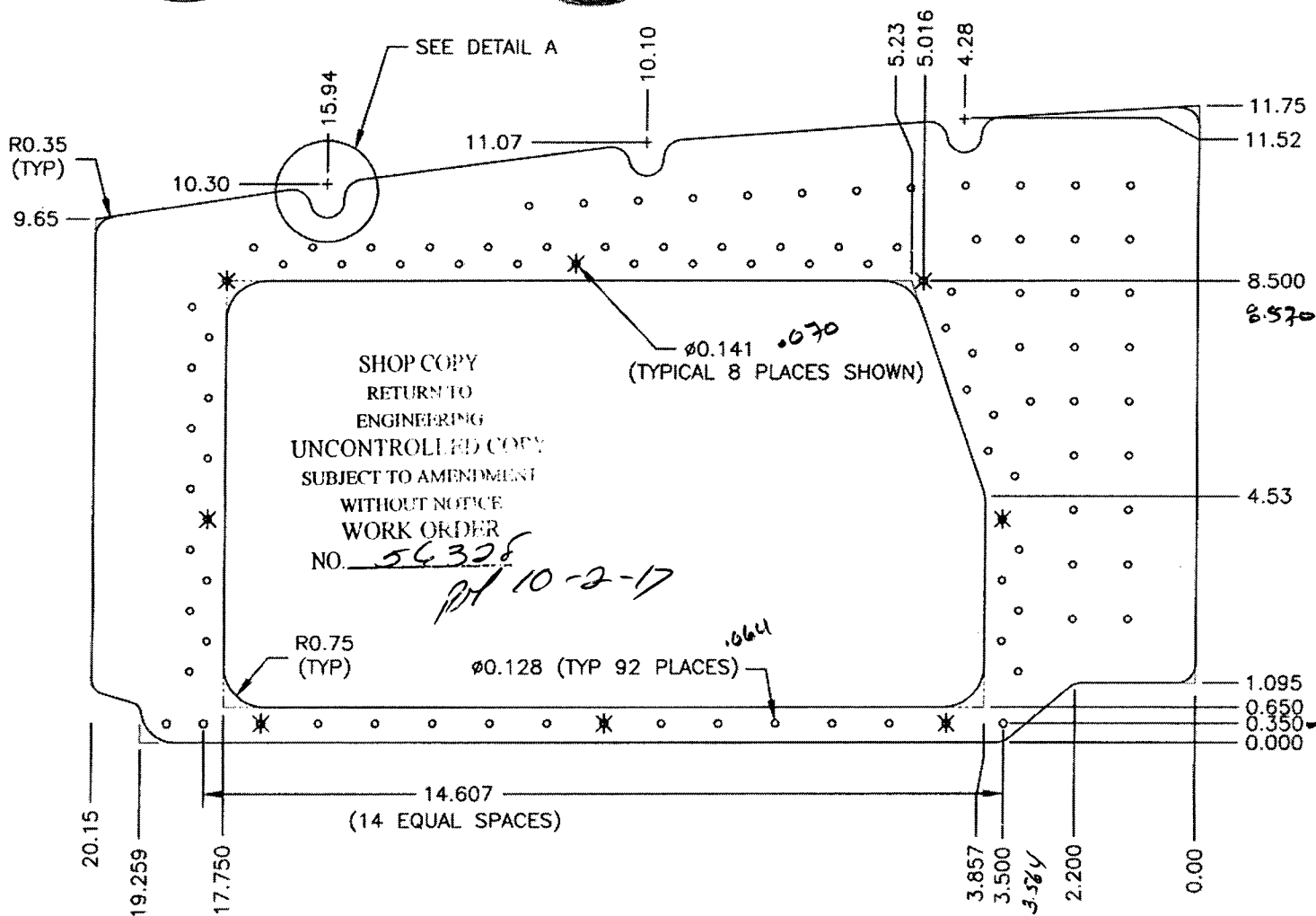
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DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. A	
		D3210		SHEET 1 OF 1	
DATE		TITLE		SCALE	
03.09.03		DOUBLER		1:3	
A	03.09.03	NEW ISSUE		9	

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03-29-15



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